

# Work Order ID 86126

Wednesday, June 20, 2012 3:41:21 PM

**\*86126\***

*Ship monday* Page 1

Item ID: D4423-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Splash Guard Extension

Stop **\*NS2\***

Start Date: 6/21/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 7/23/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: *MVF*

Date: *12-06-20* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4423

A

100

0.00

**\*100\***

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4423

Dwg Rev: *B*

Prog rev: *A*

*6061, 032"*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*4 0 Jun 12-6-20*

*4 0 Jun 12-6-20*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 86126****\*86126\***

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Cust Item ID:

Required Date: 7/23/2012 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

4

12/06/21

140

NC BRAKE

0.00

**\*140\***

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3065

④

8/12/06/25

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

4

12/06/25

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Item Name: Splash Guard Extension

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**\*NS2\***

Start Date: 6/21/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 7/23/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

**\*160\***

HandFinish

Memo

0.00

Hand Finishing

4 126 12-6-25

165

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

**\*165\***

Powdercoat

Memo

0.00

Powder Coating

12:27 11:50  
300°  
16:20

H 126 12-6-25

170

QC3- Inspect Part Finish

0.00

**\*170\***

QC

Memo

0.00

Quality Control

4 126 12-6-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 7/23/2012 Req'd Qty: 4.00

**\*4\***

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: 110

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

12/6/2712/6/28MF 12-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, June 20, 2012 3:41:21 PM

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Work Order ID: 86126  
Parent Item: D4423-1  
Parent Item Name: Splash Guard Extension

Start Date: 6/21/2012 Required Date: 7/23/2012  
Start Qty: 4.00 Required Qty: 4.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No				sf	263.8960		1.8867368			
6061-T6 Sheet 0.032"													

Jm 12-6-20

Location

Loc Qty

Loc Code

MAT021

263.896

118106

46.136

120218

23.92

120285

42.24

121099

151.6

120218

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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

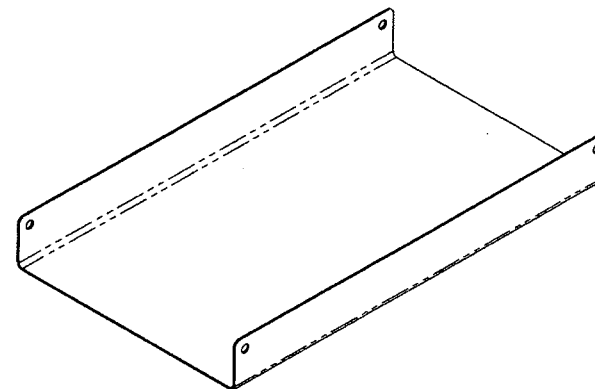
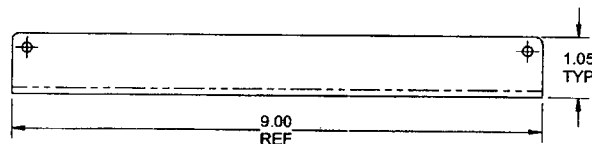
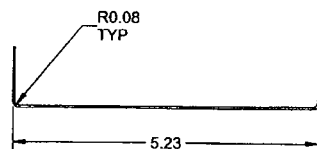
C

B

B

A

A



**D4423-1 SPLASH GUARD EXTENSION**

**RELEASED**  
2011-07-06

**NOTES:**

- 1) MATERIAL: MAKE FROM D4423-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4423-1" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.20 lbs

REV.	NEW ISSUE	DESCRIPTION	MB	11.06.22
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	11.06.22			

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4423** REV. A  
SHEET 1 OF 2

TITLE **SPLASH GUARD EXTENSION** SCALE NTS

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8 7 6 5 4 3 2 1

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